

Date: Monday, 12/01/2009 2:31:19 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT STRUT ASSEMBLY
Job Number :	44582		
Estimate Number :	11286		
P.O. Number :		Part Number :	D3437041
This Issue :	12/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3437 REV B
First Issue :	//	Project Number :	N/A
Previous Run :	39869	Drawing Revision :	B
Written By :		Material :	
Checked & Approved By :	<u>JLD 09-01-12</u>	Due Date :	30/01/2009
Comment :	Est. A 05.05.20 New Issue KJ/JLM	Qty:	360 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34371	Foot
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Foot

Pick:

Qty	Part Number	Description	Batch
1	D3437-1	Foot	41953

2.0	D34373	Clip
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Clip

Pick:

Qty	Part Number	Description	Batch
1	D3437-3	Clip	43178

3.0	D343711	Eyebolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Eye Bolt

Pick:

Qty	Part Number	Description	Batch
1	D3437-11	Eye Bolt	39893

4.0	MS210435	Nut
-----	----------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Self Locking Nuts

Pick:

Qty	Part Number	Description	Batch
1	MS21043-5	Self Locking Nut	109535

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT STRUT ASSEMBLY

Job Number: 44582

Part Number: D3437041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D3437
Dwg Rev: B

09/01/20 (3)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/01/20 (43)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST199

09/01/21 (X3)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/21

Job Completion



U 09.01.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

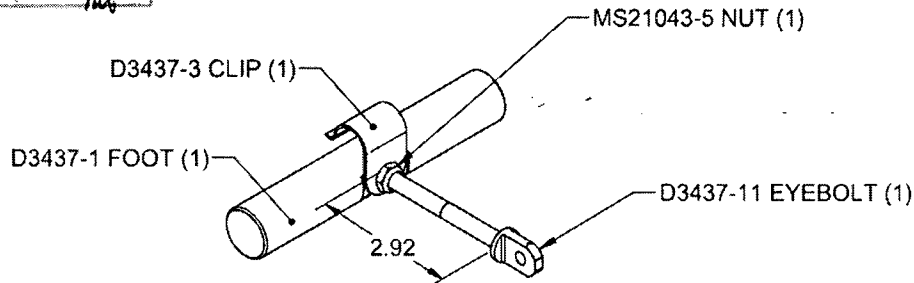
NOTE: Date & initial all entries



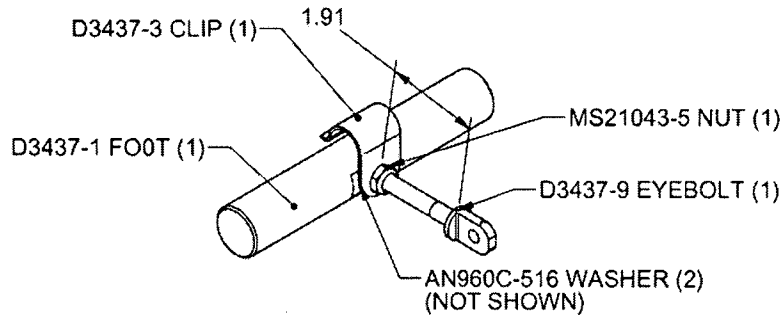
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3437	REV. B SHEET 1 OF 4
DATE 05.08.11		TITLE AFT STRUT ASSEMBLY	SCALE 1:2
A	05.04.29	NEW ISSUE	
B	05.08.11	UPDATE D3437-5/-9/-11 DIMENSIONS	

RELEASED

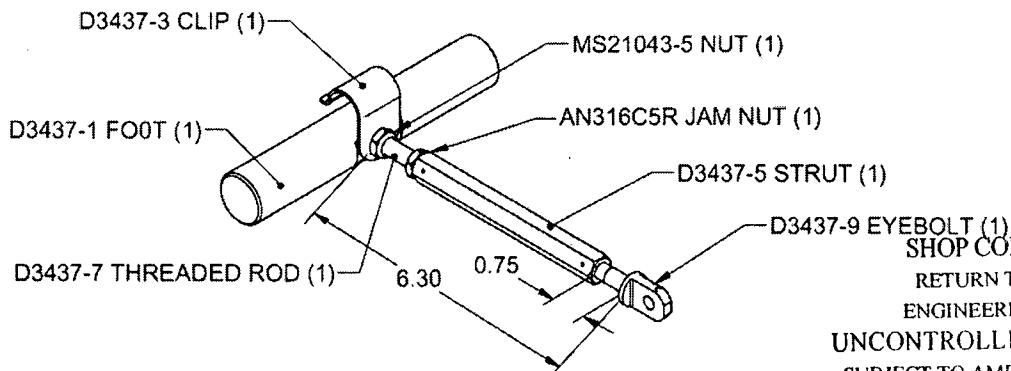
05.08.11 *[Signature]*



D3437-041 AFT STRUT ASSEMBLY



D3437-043 AFT STRUT ASSEMBLY



D3437-045 AFT STRUT ASSEMBLY

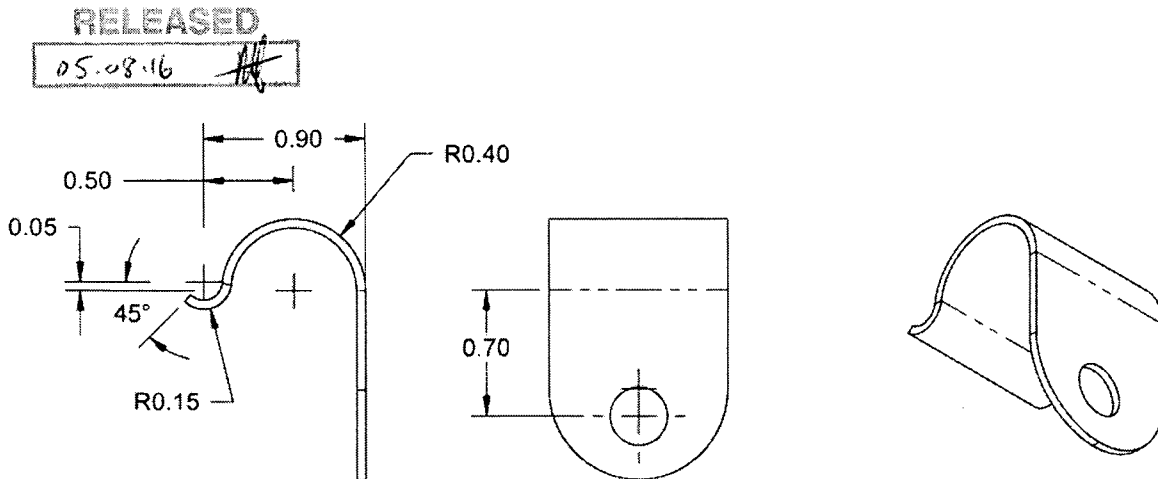
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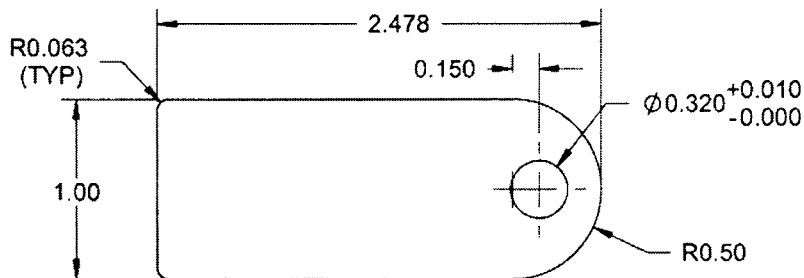
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DATE 05.08.11		TITLE AFT STRUT ASSEMBLY	SCALE 1:2



D3437-3 CLIP
SCALE 1:1



D3437-3
FLAT PATTERN

D3437-3 CLIP:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.050 THICK (REF DART SPEC M304S18CA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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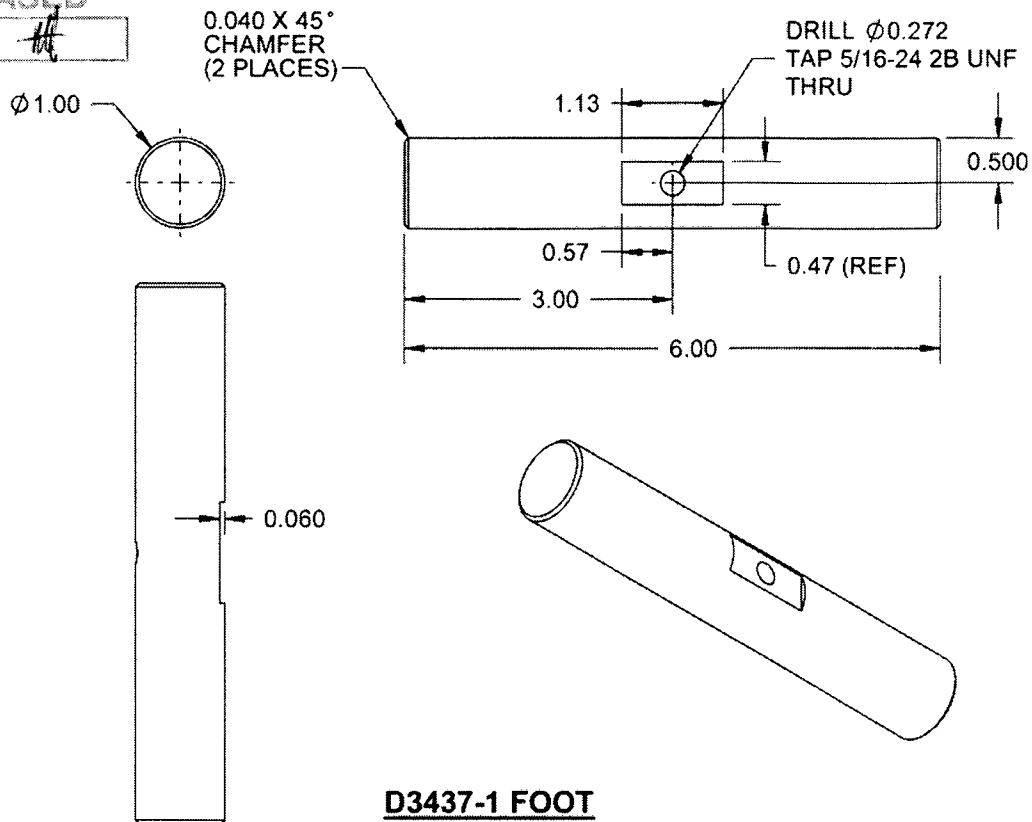
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DATE 05.08.11		TITLE AFT STRUT ASSEMBLY	SCALE 1:2

RELEASED

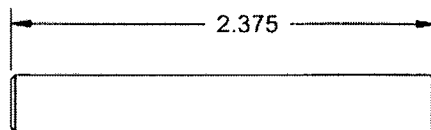
05-08-16 *[Signature]*



D3437-1 FOOT

D3437-1 FOOT:

- 1) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) ALUMINUM ROUND BAR
(REF. DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010



D3437-7 THREADED ROD

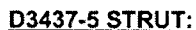
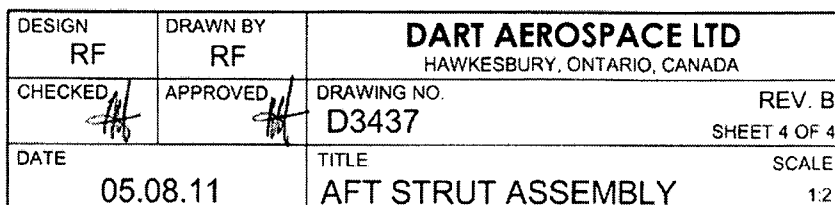
D3437-7 THREADED ROD:

- 1) POSSIBLE SUPPLIER: HASKINS-SPAENAU P/N 870-832 18-8 5/16-24 SS THREADED ROD
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

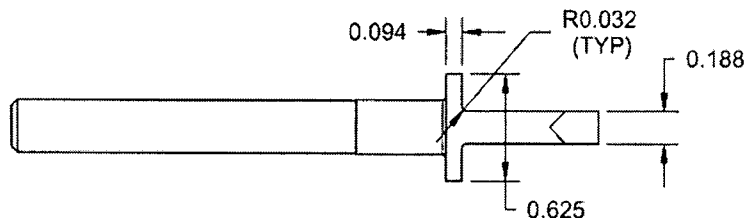
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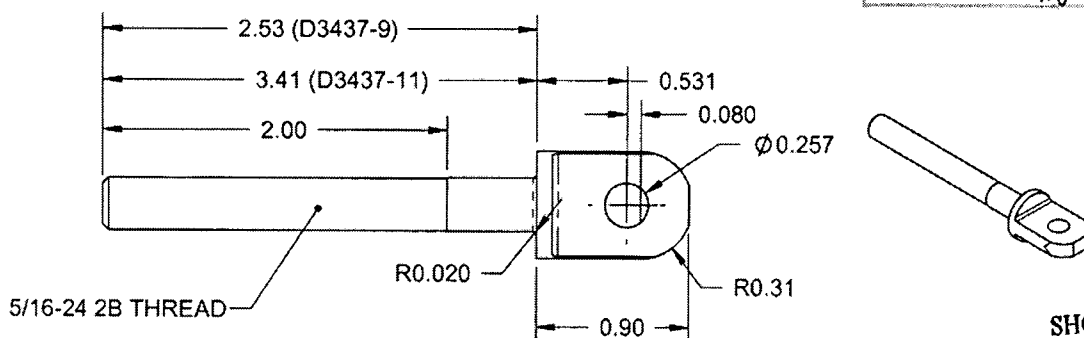
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- 1) MATERIAL: AISI 303 STAINLESS HEX BAR (DART REF. SPEC M303H0.500)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010



RELEASED



D3437-9/-11 EYEBOLT:

- 1) MATERIAL: AISI 303 STAINLESS ROUND BAR (DART REF. SPEC M303R)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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